

Work Order ID 52521



Page 1

September 29, 2009 10:48:31 AM

Item ID: D3043-041

Accept



Setup Start



Revision ID: A

Stop

Item Name: Ste_p Weldment LH, A119

Start Date: 29/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: 09.9.29

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3043	Rev A

100



Large Fab

0.00

4 φ

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G02-Deburr and bevel ends for welding

109-10-02

110



QC5- Inspect part completeness to step on W/O

0.00

2) S o l w o l s

(X) φ

QC

Memo

0.00

Quality Control

120



Large Fab

0.00

4 φ

Large Fab

Memo

0.00

Large Fab

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802AR AL ROD Batch: M111311 2-Grind Fwd End Cap weld flush

M111494

109-10-13

Work Order ID 52521

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September 29, 2009 10:48:31 AM

Item ID: D3043-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Step Weldment LH, A119

Start Date: 29/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Large Fab	0.00							
	Memo	0.00							
	1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR ALROD Batch: M111311 2-Inspect for foreign object as per QSI024 3-Grind Fwd End Cap weld flush								
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
QC									
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
QC									
Quality Control									

2) Seq 10/17

(X446)

✓

Work Order ID 52521

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Setup Start



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Stop



Item Name: Step Weldment LH, A119

Start Date: 29/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Chemical Conversion Coat per QSI005 4.1	0.00				(4)			
HandFinish	Memo	0.00							
Hand Finishing									

200



QC3- Inspect Part Finish

0.00

MD 09/10/19

X4

QC

Quality Control

0.00

210



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112 260

Memo

0.00

BL 09-10-19

(3)

Powdercoat

Powder Coating

START TIME: 12:00

FINISH TIME: 12:30

OVEN TEMPERATURE:

Work Order ID 52521



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September 29, 2009 10:48:31 AM

Item ID: D3043-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Step Weldment LH, A119

Start Date: 29/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Wing wash & air as per QSI005 4.3

0.00

S 4/10/20

0.00

MD 09/10/20

(4)

230



QC3- Inspect Part Finish

0.00

MD 09/10/20

QC

Quality Control

Memo

0.00

(X4)

∅

240



Identify as per dwg & Stock Location: _____

0.00

Packaging

Packaging

Memo

0.00

PPR
52521

10/10/20 (4)

Work Order ID 52521

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September 29, 2009 10:48:31 AM

Item ID:	D3043-041	Accept		Setup	Start			
Revision ID:	A				Stop			
Item Name:	Step Weldment LH, A119							
Start Date:	29/09/2009	Start Qty:	4.00		Cust Item ID:			
Required Date:	16/10/2009	Req'd Qty:	4.00		Customer:			
Reference:						Run	Start	
Approvals:	Process Plan:	Date:	Tooling:	Date:		Stop		
	QC:	Date:	SPC (Y/N):	Date:				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	QC21- Final Inspection - Work Order Release	0.00							<i>09/10/21 JF</i>
QC	Memo	0.00							<i>MF</i> <i>09-10-21</i>

Quality Control

Picklist Print

Page 2

September 29, 2009 10:48:31 AM

Work Order ID: 52521



Parent Item: D3043-041RevA



Parent Item Name: Step Weldment LH, A119

Start Date: 29/09/2009

Required Date: 16/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3040-1RevB		Manufactured	No			120	Each	56.0000	8.0000		12/09/2009	10:02

Mounting Lug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

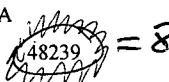


1

1

Main Warehouse

WA



55

55

8

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3043	SHEET 1 OF 2
DATE	TITLE		SCALE
01.06.28	A119 STEP WELDMENT		NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 NO. 5252

PL 09-9-29

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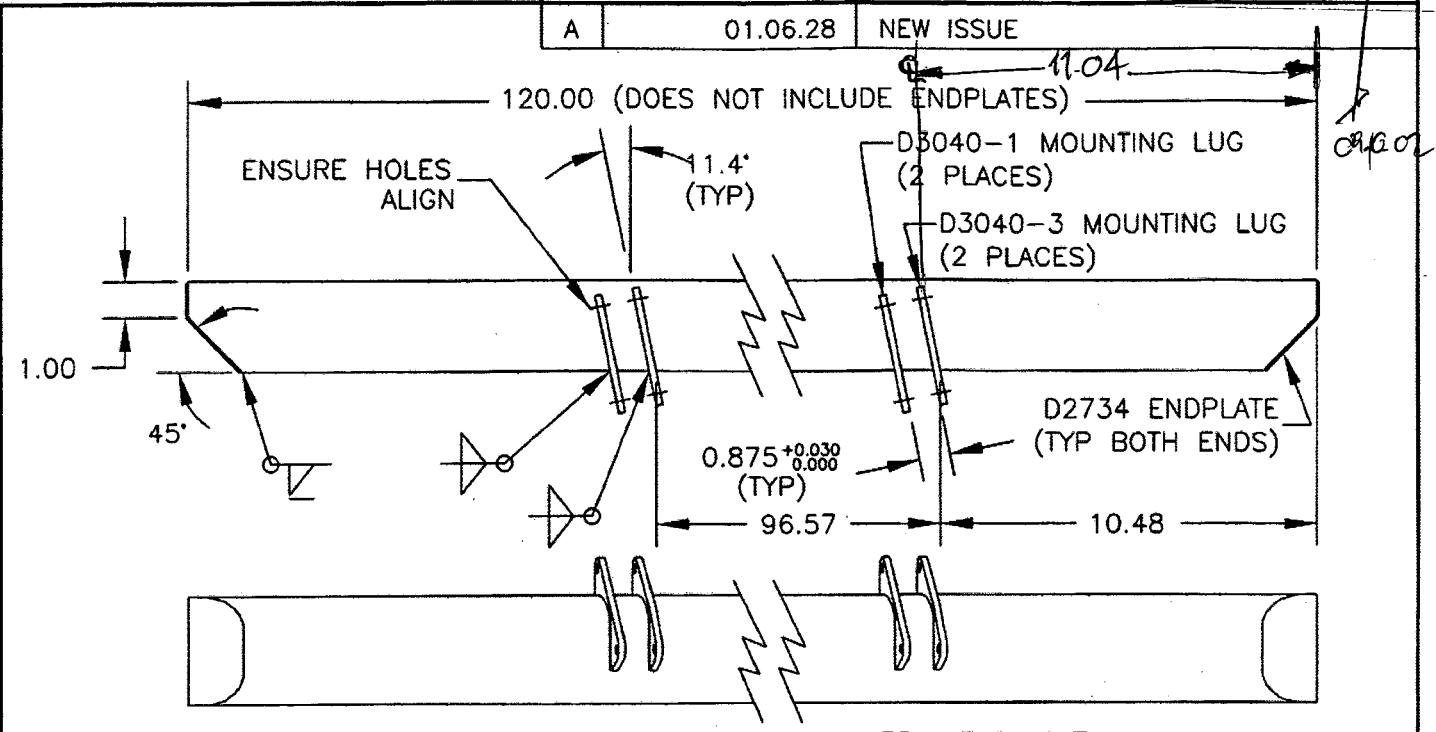
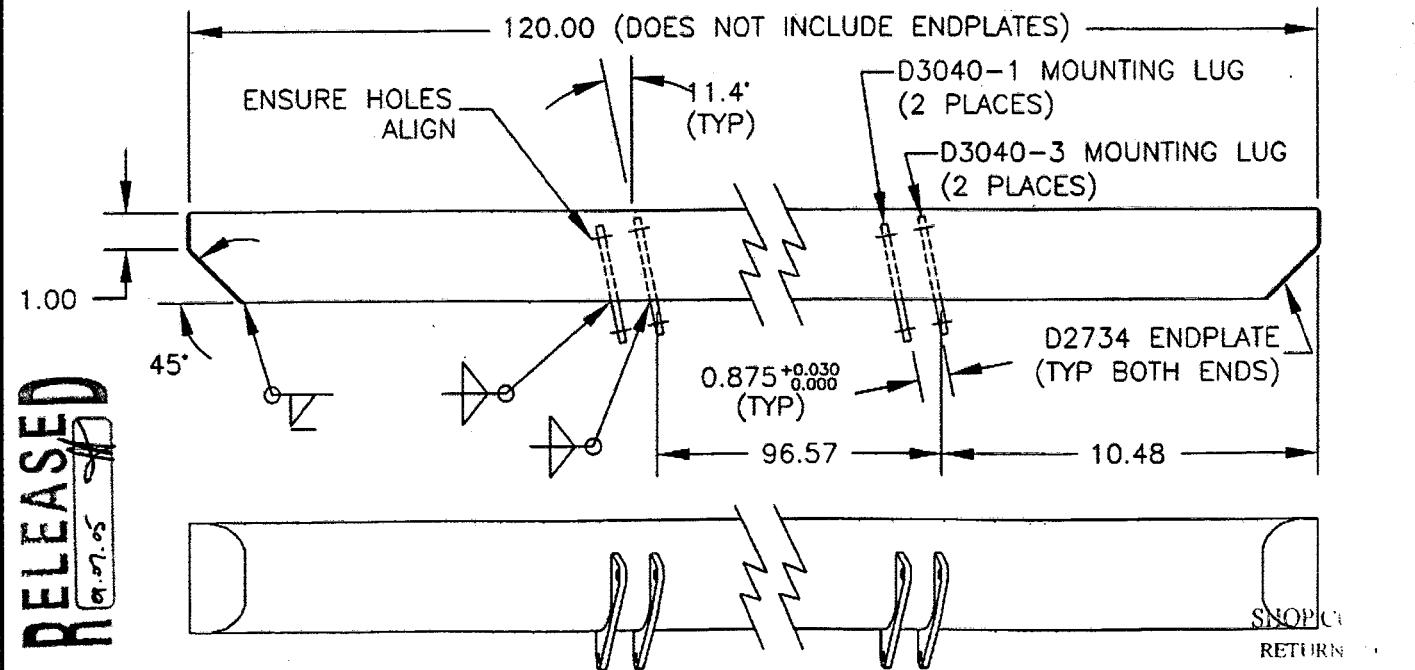
01.07.05 *CP*

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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	

VIEW A-A: D3043-041 LH STEP WELDMENTVIEW A-A: D3043-042 RH STEP WELDMENT

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Rev 09-925